

Work Order ID 51828

September 4, 2009 9:13:07 AM



Page 1

Item ID: D3846-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: GASKET

Start Date: 09/04/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 09-09-04 Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3846

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3846

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B 9-9-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-9-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51828

September 4, 2009 9:13:07 AM



Page 2

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Setup Start



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Item Name: GASKET

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

2) 8/21/09/10



QC

Memo

0.00



/

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

9/19/10 (B) S

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/11 XJ

Quality Control

W 09.09.11

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NOTE: Date & initial all entries

Picklist Print

September 4, 2009 9:13:06 AM

Page 1

Work Order ID: 51828



Parent Item: D3846-5RevB



Parent Item Name: GASKET



Start Date: 09/04/2009

Required Date: 09/11/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	496.5411	6.1674	8.2232		
NEOPRENE SHEET 0.063										13 9940		

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

496.5410585

111469

71.1

111853

96.7589585

112508

328.6821

112508

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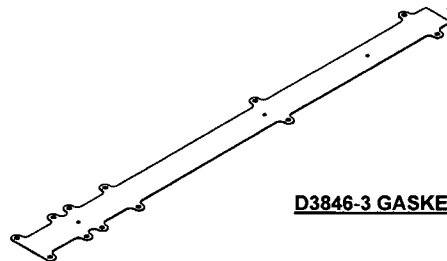
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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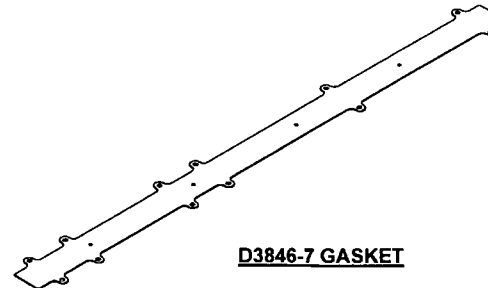
NOTE: Date & initial all entries



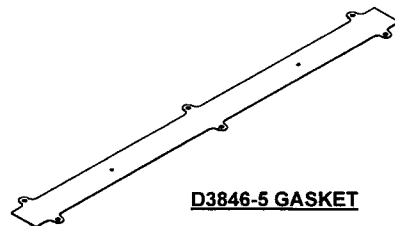
D3846-1 GASKET



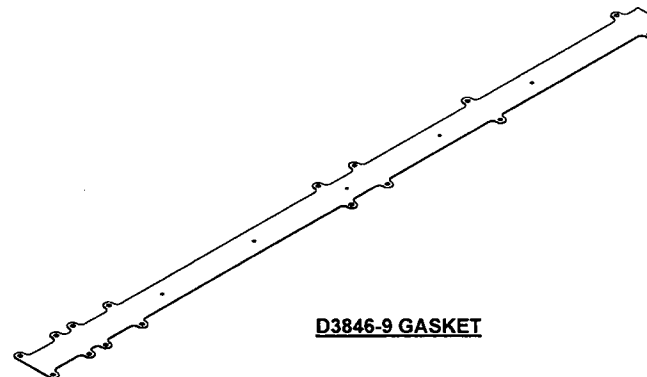
D3846-3 GASKET



D3846-7 GASKET



D3846-5 GASKET



D3846-9 GASKET



D3846-11 GASKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51828

MF 09-09-04

RELEASED
09/15/04

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER
- 7) WEIGHT:
 - D3846-1 = 0.03 lbs
 - D3846-3 = 0.25 lbs
 - D3846-5 = 0.20 lbs
 - D3846-7 = 0.26 lbs
 - D3846-9 = 0.35 lbs
 - D3846-11 = 0.04 lbs

B	5.82 WAS 6.25 (ZN C4-2); 45.28 WAS 45.71 (ZN A4-3); 6.32 WAS 6.78 (ZN B2-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
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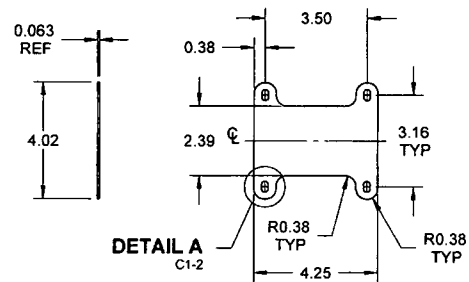
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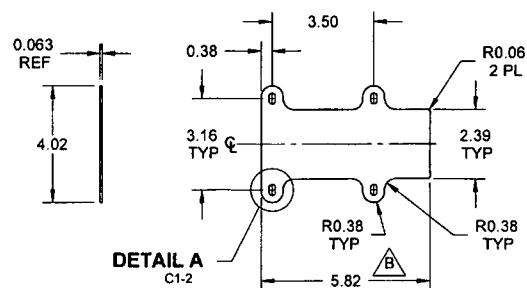
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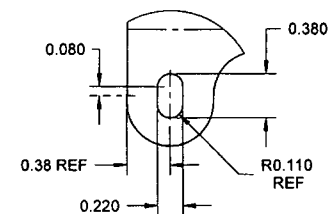
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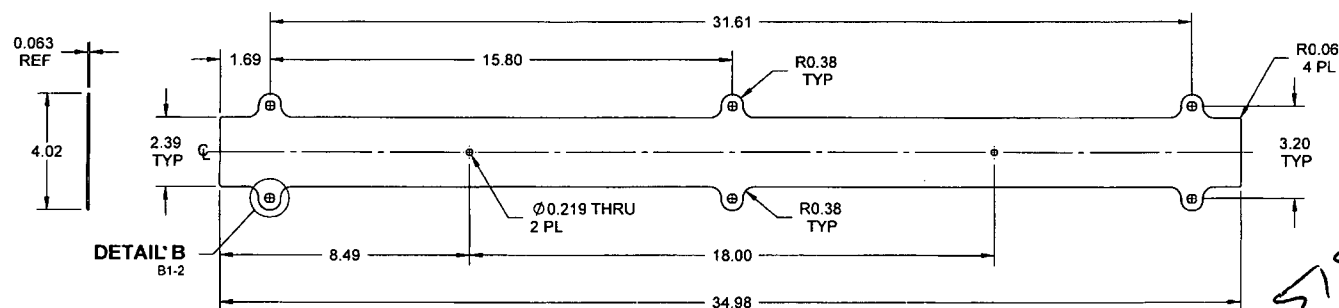
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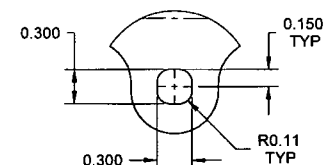
D3846-11 GASKET



DETAIL A C5-2 C7-2
TYP. SCALE 4X



D3846-5 GASKET



DETAIL B A7-2 C5-3 B7-3 C5-4
TYP. SCALE 4X

RELEASED
09/07/15

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CHECKED	<i>PD</i>	DRAWING NO. D3846	REV. B
MFG. APPR.	<i>MP</i>	SHEET 2 OF 4	
APPROVED	<i>MP</i>	TITLE	SCALE
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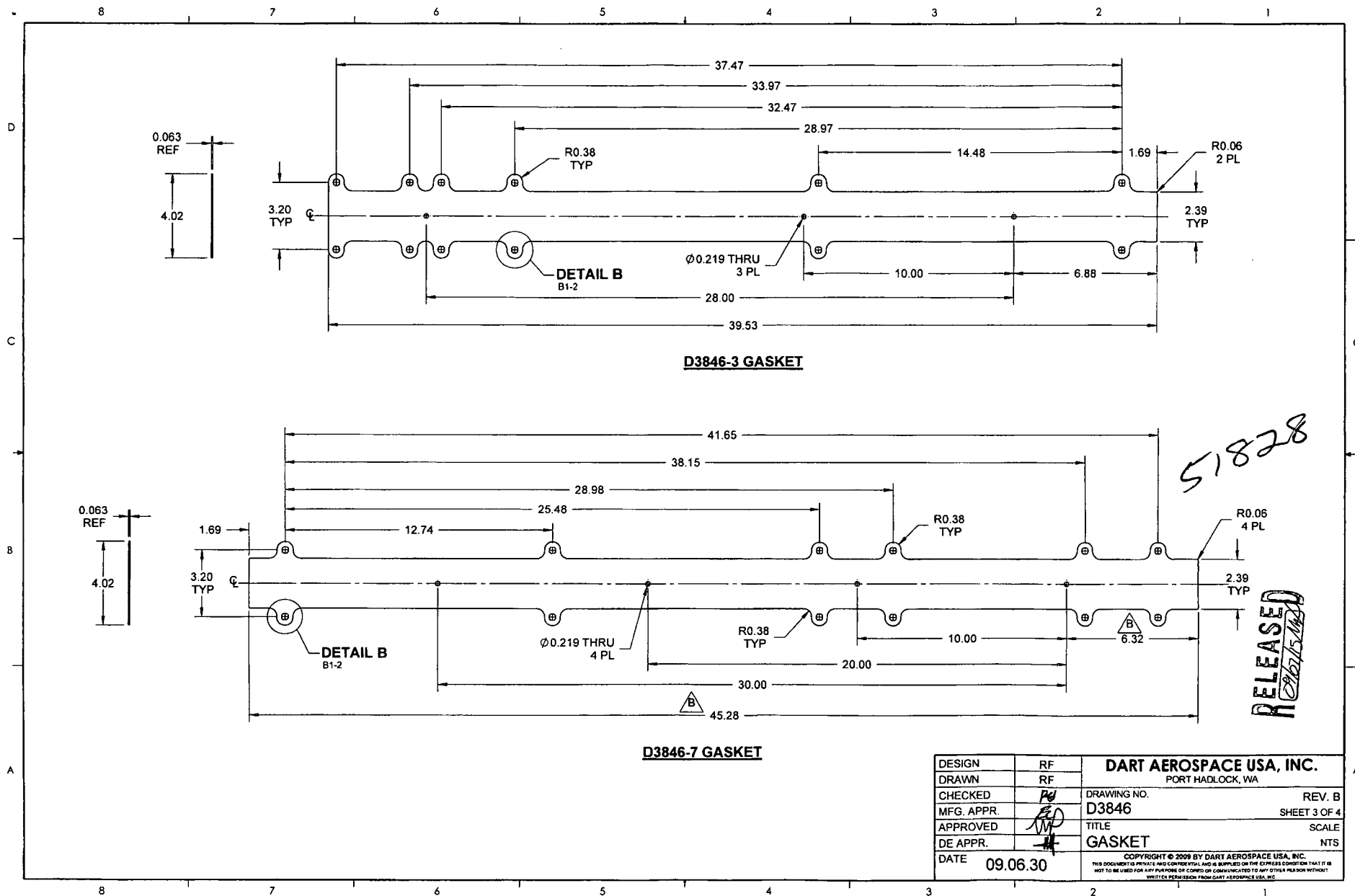
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8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

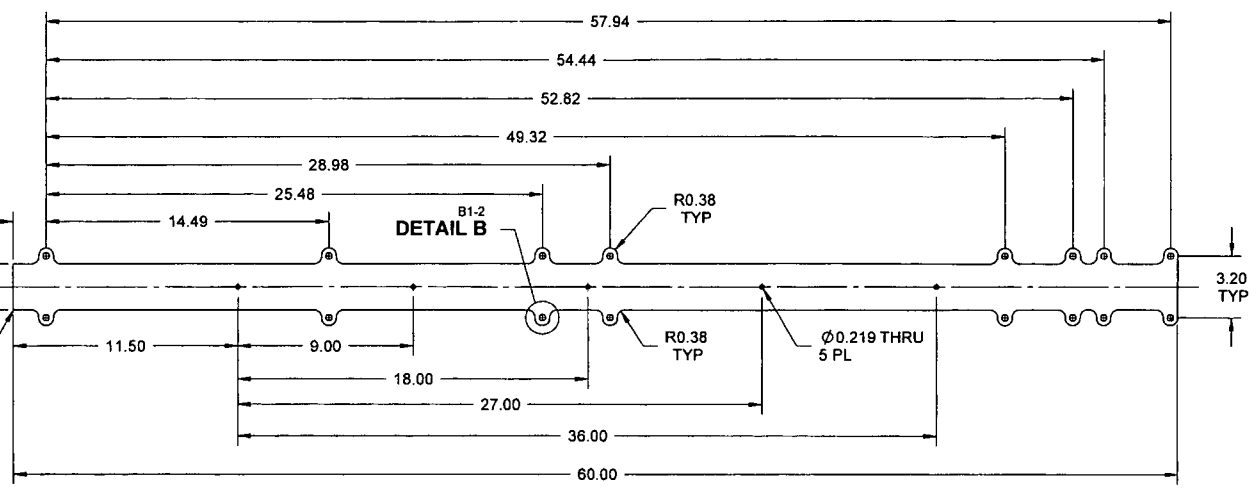
A

0.063
REF

4.02

R0.06
2 PL

1.69
2.39
TYP



D3846-9 GASKET

51828

RELEASED
27/07/15

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3846	REV. B
MFG. APPR.	RF	SHEET 4 OF 4	
APPROVED	RF	TITLE GASKET	SCALE
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8 7 6 5 4 3 2 1

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